

Date: Monday, 18/08/2008 4:03:23 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER		
Job Number	: 41338		REVIEW	<i>N/A</i>		
Estimate Number	: 10495		Part Number	: D2360		
P.O. Number	:		Drawing Number	: D2360/D2341		
This Issue	: 18/08/2008		Project Number	: N/A		
Prsht Rev.	: NC		Drawing Revision	: D / F		
First Issue	: 18/08/2008		Material	:		
Previous Run	: 39455		Due Date	: 10/09/2008		
Written By	:		Qty:	6		
Checked & Approved By	: <u>2008-8-18</u>		Um:	Each		
Comment	: est rev H 07.06.12 ecn 825 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6201	"T" Extrusion	
		Comment: Qty.: 1.1067 f(s)/Unit Total : 6.6402 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion) Batch: <u>B36793</u>	<i>ML 08/09/14</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 12.65" Long	<i>ML 08/09/14</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2341 and Dwg D2341	<i>ML 08/09/14</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>ML 08/09/14</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>ML 08/09/17</i>
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Deburr and Tumble	<i>ML 08/09/16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/01		~250 slot 15 low because of vise jaws and X axis origin						

NOTE: Date & initial all entries

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Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5



INSPECT WORK TO CURRENT STEP

N/A 10.08/17

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

(Ex)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M/b 08/09/17

9.0 POWDER COATING



POWDER COATING



M108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:00 pm

OVEN TEMPERATURE: 326°F

FINISH TIME: 1:30 pm

9/1 08-09-17 X6

10.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(Ex) SP

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/18

11.0 D2002015



Knob



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Knob

161710

SP

12.0 D2345



Lock Channel



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lock Channel

B3571 3947

13.0 D2366



Lock Handle



SP

B3743

Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Inventory

14.0 D2367



Handle Knob



(Ex)

B33794

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

8/9/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 D2372 Quick Release



41426



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Quick Release

16.0 D2373 Spring



26458 36922



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Spring

17.0 D2444 Pip Pin Assembly



41429



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Pip Pin Assembly

18.0 AN526C1032R18 Screw



4523



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Screw

19.0 AN960JD10 Washer



104517



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Washer

20.0 AN960JD10L Washer



105793



SP

Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)  
Washer

21.0 MS20470AD34 Rivet,Universal Head



15541



SP

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Rivet,Universal Head

22.0 MS21042L3 Nut



Nut

15

3

103641

104625



6x

Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Nut

8/1/18

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:23 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 41338

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 MS27039113

Screw



13719



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Screw

SP

24.0 MS27039115

Screw



108169



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

SP

25.0 NAS679A3W

Nut



WT63



6X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

SP

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



8/9/18



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2360

EP 08/09/18 (6)

27.0 QC5

INSPECT WORK TO CURRENT STEP



So 08/09/18 (6)

Comment: INSPECT WORK TO CURRENT STEP

28.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

ST188

EP 08/09/19 (6)

29.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/19 (6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



~MF 08-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<u>41338</u>
<b>Description:</b> Litter Tie Down Bracket (Locking)	<b>Part Number:</b>	<b>D2341</b>
<b>Inspection Dwg:</b> D2341 <b>Rev:</b> F		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

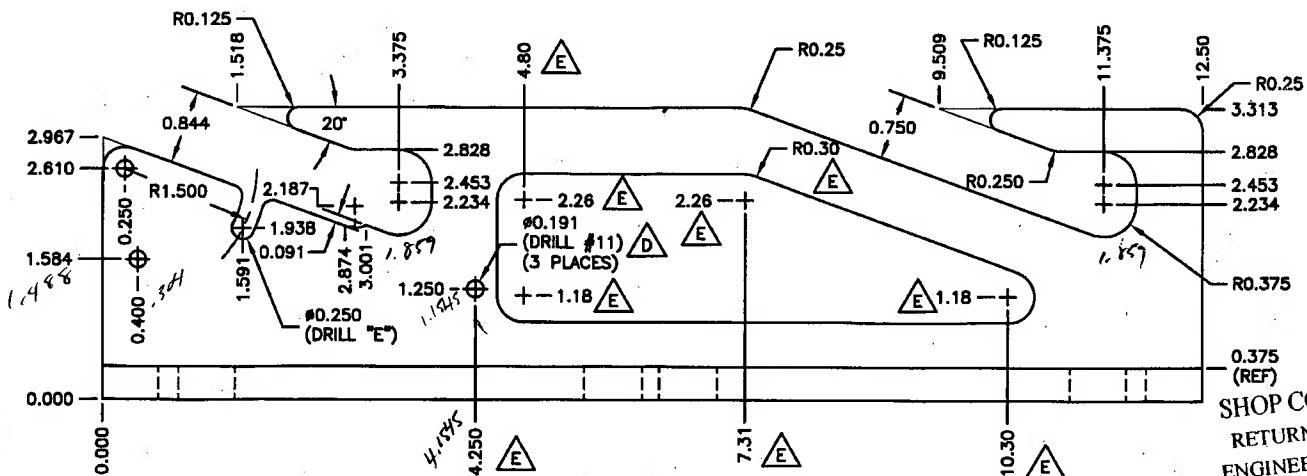
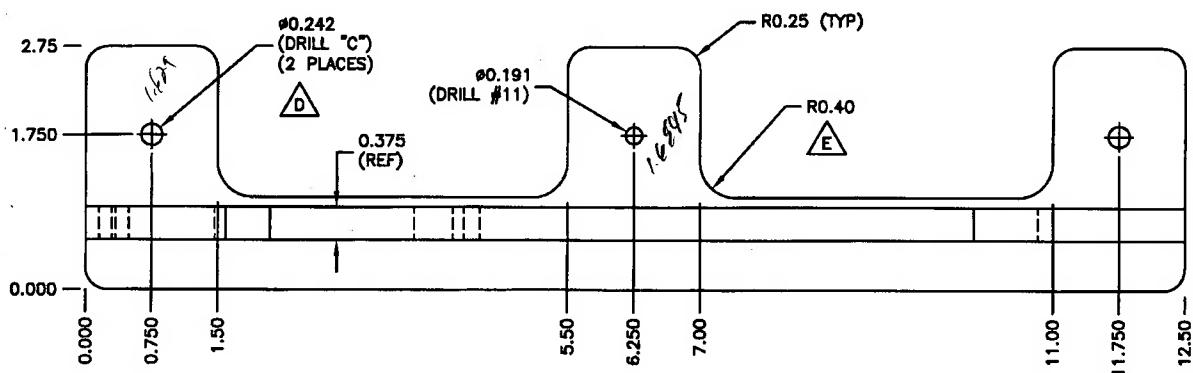
## X First Article      Prototype

Measured by:	RC	Audited by:	SP	Prototype Approval:	N/A
Date:	08/09/16	Date:	08/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	22

**DART**

DESIGN BW	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>AB</i>	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	



**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION  
(6061-T6/T651 PER QQ-A-200/8)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3  
3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT  
PERMANENT INK MARKER

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WITHOUT NOTICE

RELEASED *1/3*

07-06-22 *AB*

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>SH</b>	DRAWING NO. <b>D2360</b>	REV. D SHEET 1 OF 2
DATE <b>07.06.06</b>		TITLE <b>LITTER TIE DOWN ASSEMBLY (LOCKING) NTS</b>	SCALE
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

**RELEASED**07.06.07 **SH****PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	<b>D2360</b>	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	<b>D2341</b>	LITTER TIE DOWN (LOCKING)
1	<b>D2345</b>	LOCK CHANNEL
2	<b>D2366</b>	LOCK HANDLE
1	<b>D2367</b>	KNOB (DELRIN)
2	<b>D2372</b>	QUICK RELEASE FASTENERS
1	<b>D2373</b>	SPRING
2	<b>D2002-015</b>	KNOB (DELRIN)
1	<b>D2444</b>	PIP PIN
1	<b>AN526C1032R18</b>	SCREW
2	<b>AN960JD10</b>	WASHER
8	<b>AN960JD10L</b>	WASHER
1	<b>MS20470AD3-4</b>	RIVET
3	<b>MS21042L3</b>	NUT (OR MS21042-3)
1	<b>MS27039-1-13</b>	SCREW
2	<b>MS27039-1-15</b>	SCREW
1	<b>NAS679A3W</b>	NUT

**D****D****D**

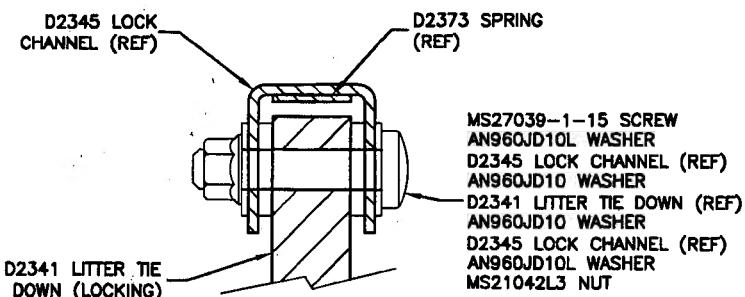
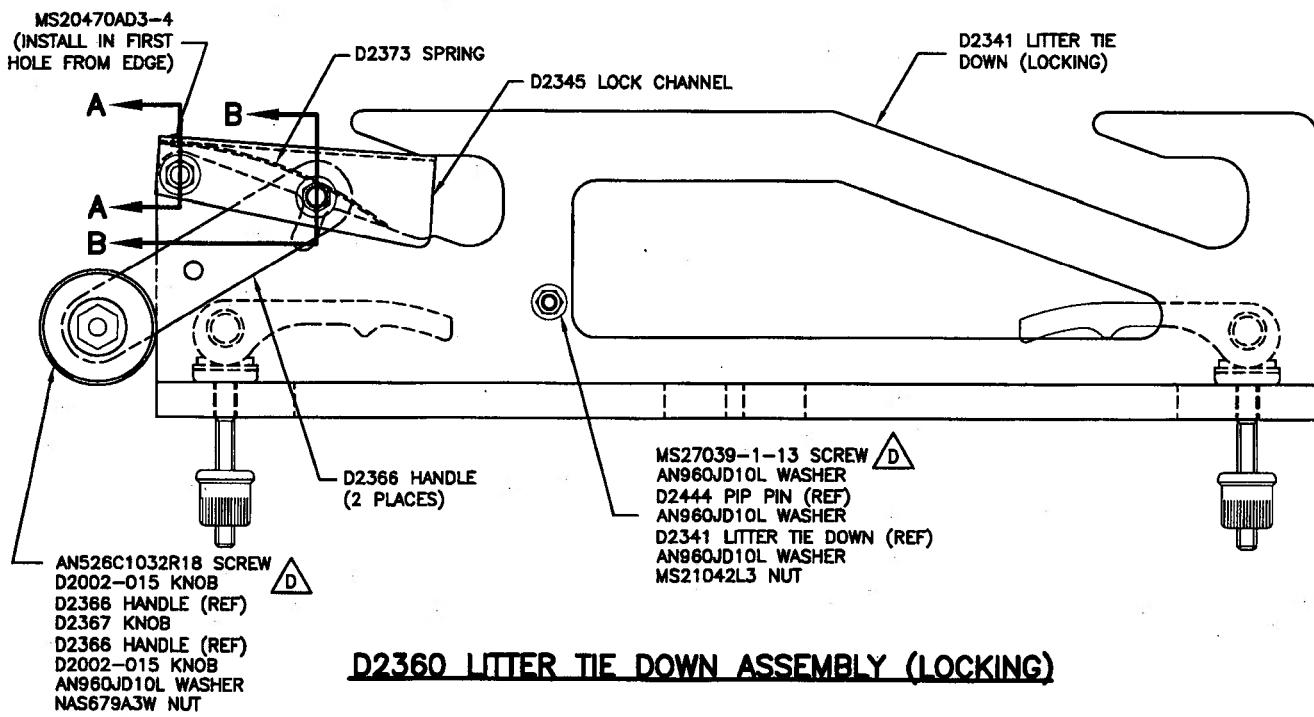
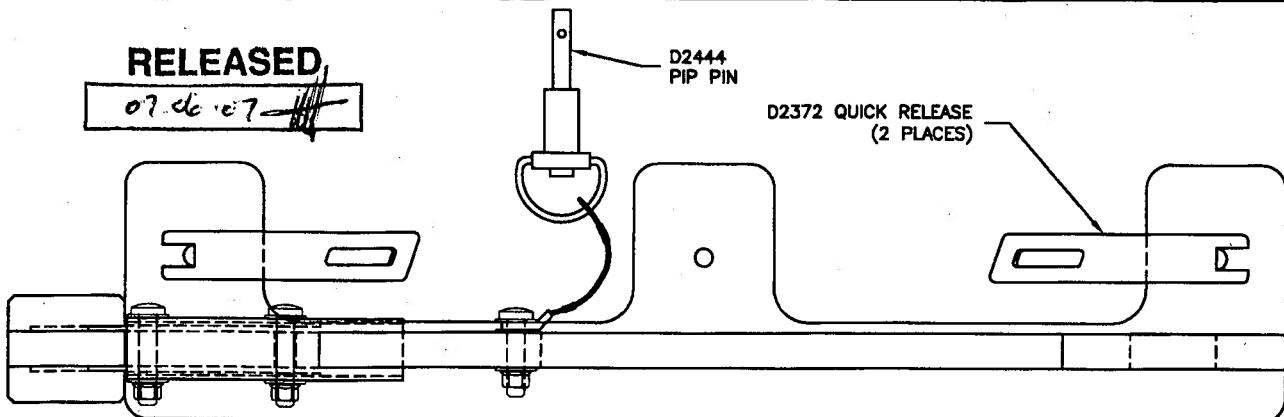
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WORK ORDER  
NO. **11338**

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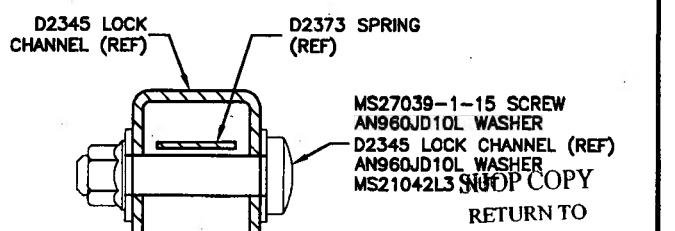
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**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>H</b>	DRAWING NO. <b>D2360</b>	REV. D SHEET 2 OF 2
DATE <b>07.06.06</b>		TITLE <b>LITTER TIE DOWN ASSEMBLY (LOCKING) NTS</b>	SCALE

**RELEASED**07.06.07 ~~07.06.07~~

**SECTION A-A**  
(SCALE 1:1)



**SECTION B-B**  
(SCALE 1:1) D

